

Work Order ID 67844

Thursday, March 31, 2011 3:48:11 PM



Page 1

Item ID: D3023-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Back Panel

Start Date: 4/1/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: 4/30/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3023	Rev A								
100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
2024.032	1-Cut as per Dwg D3023								
	Dwg Rev: <i>A</i>								
	Prog Rev: <i>A</i>								
	***graind direction along 28.100" ***								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							

B11-4-6

①

B11-4-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

NC BRAKE

0.00



Brake NC

Memo

0.00

Brake NC

1-Bend as per Dwg D3023-2-form edge of back pan as per dwg D3023 using
D3017-041 back frame

Subtotal

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

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Page 3

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Required Date: 4/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

ml 11 04 21 ①

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 12:00 OVEN TEMPERATURE:
1130 FINISH TIME: 320

ml 11 04 21 ①

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

EBH/04/25 ②

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Page 4

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Identify as per dwg & Stock Location: *G.A*

0.00



Packaging

Memo

*w/o
67840*

0.00

Packaging

ES 11/04/25 @

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/4/25 @**PL 11-09-25
①*

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Picklist Print

Thursday, March 31, 2011 3:48:17 PM

Page 1

Work Order ID: 67844

Parent Item: D3023-1

Parent Item Name: Back Panel



Start Date: 4/1/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP C 02.01.23 Revised NG
IPP Rev:D 08-04-16 now water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.032		Purchased	No			100	sf	58.9000	2.8777	3.029158			
--------------	--	-----------	----	--	--	-----	----	---------	--------	----------	--	--	--



2024-T3 .032 sheet



HSI-4-6

Location

Loc Qty

Loc Code

MAT22

58.9

105555

0.4

111699

0.5

113189

58

113189

①

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DART AEROSPACE LTD		Work Order:	67844
Description: Back Panel		Part Number:	D3023-1
Inspection Dwg: D3023 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.131	X		V RB02	
Ø0.191	+0.005/-0.001	.194	X		V	
1.660	+/-0.010	1.660	X		V	
0.375	+/-0.010	.374	X		V	
1.340	+/-0.010	1.338	X		V	
2.375	+/-0.010	2.377	X		V	
0.375	+/-0.010	.373	X		V	
25.28	+/-0.030	25.28	6		T RB01	
27.03	+/-0.030	27.03	X		T	
28.10	+/-0.030	28.10	X		T	
1.30	+/-0.030	1.297	X		V	
2.375	+/-0.010	2.377	X		V	
8.711	+/-0.010	8.711	6		T	
5.597	+/-0.010	5.597	T		T	
8.57	+/-0.030	8.57	X		T	
1.970	+/-0.010	1.970	6		V	
7.42	+/-0.030	7.42	X		T	
10.92	+/-0.030	10.92	X		T	
14.75	+/-0.030	14.75	X		T	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 11-4-10	Date: 11/04/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.27	New Issue	KJ/EC	AS

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

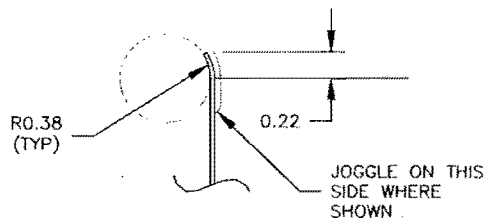
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

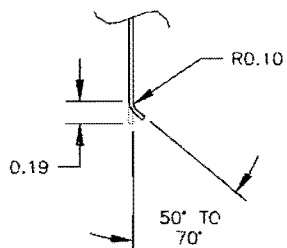
NO. 67844

PR1103-31

SECTION A-A
SCALE 1:1
(TYPICAL, EXCEPT WHERE SHOWN)

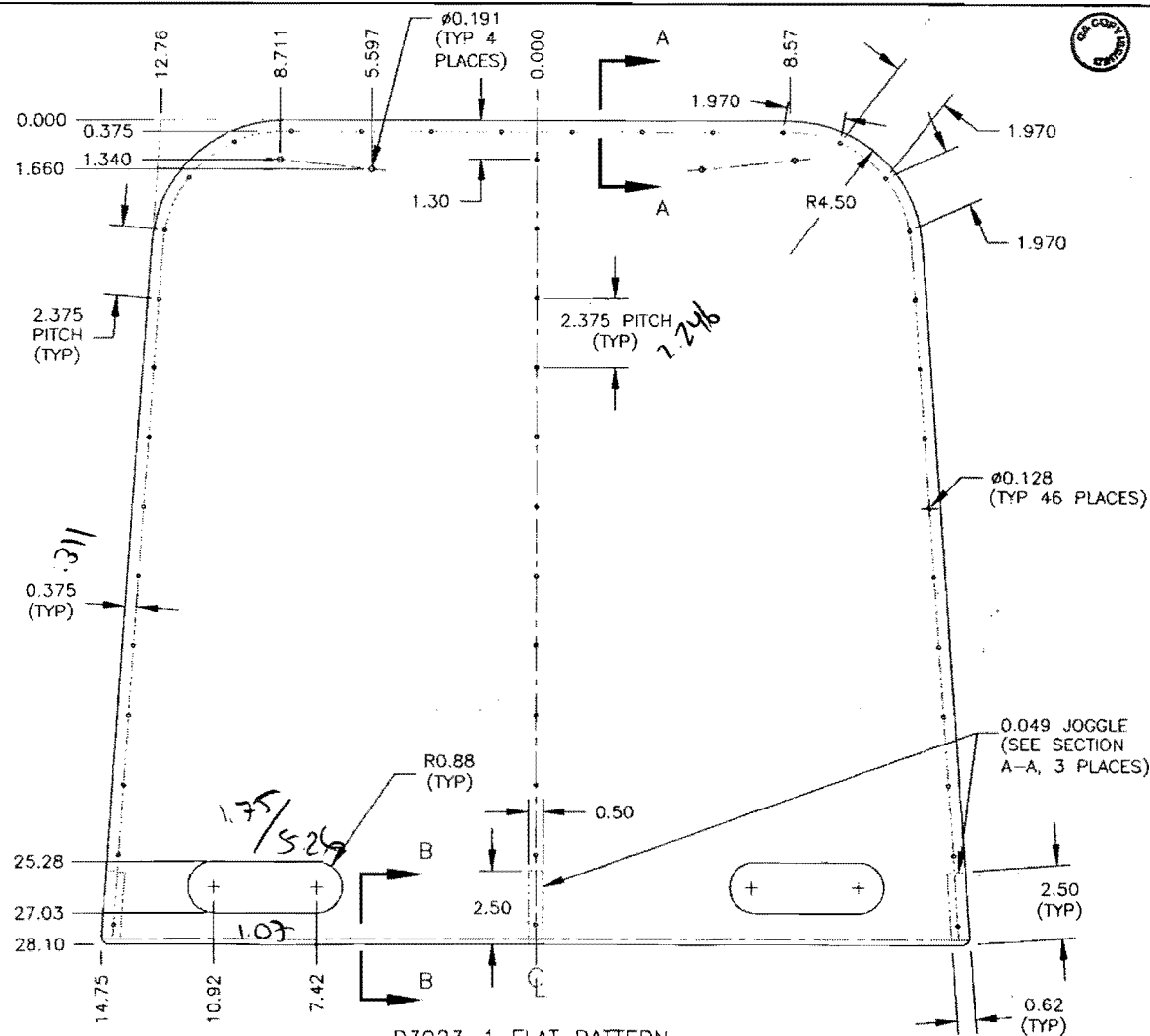


SECTION B-B
SCALE 1:1
(BOTTOM EDGE ONLY)



RELEASED
9.06.07

D3023-1 BEND DETAIL



D3023-1 FLAT PATTERN

D3023-1 BACK PANEL:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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DART AEROSPACE LTD.

A	01.05.18	NEW ISSUE
DESIGN	CP	DRAWN BY CP
CHECKED	CP	APPROVED
DATE	01.05.18	DRAWING NO. D3023
		TITLE BACK PANEL
		REV. A SHEET 1 OF 1 SCALE 1:1

DART DART AEROSPACE LTD.
WARRICK, ONTARIO, CANADA

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